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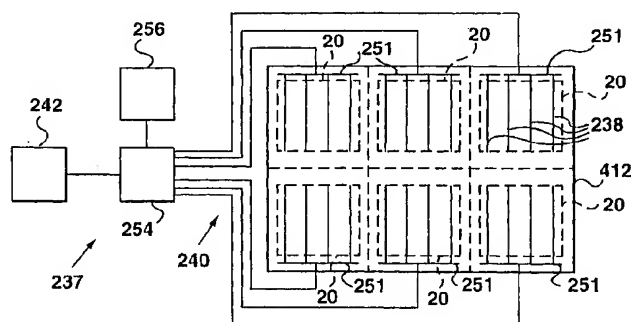
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(54) **Cyclic aeration system for submerged membrane modules**

(57) An apparatus is described for cleaning or inhibiting the fouling of a plurality of membrane modules 20 immersed in tank water 18 in a tank 12. Air is supplied through aerators 38 to produce a flow of bubbles 36 effective to clean or inhibit fouling of the membrane modules. The flow of air is alternated between a higher flow rate and a lower flow rate, the lower flow rate being less than one half of the higher flow rate, in repeated cycles

of not more than 120 seconds in duration while the permeate is withdrawn through the membrane modules 20. This produces transient flow conditions in the tank water 18, the tank water 18 being accelerated or decelerated for much of each cycle so that it is rarely in a steady state during permeation. This gives rise to efficient cleaning of the membranes without overloading the aerator system. The flow rates are controlled by a set of valves 254 and a controller 256.



**FIG. 5**

## Description

### FIELD OF THE INVENTION

**[0001]** This invention relates to filtering liquids and particularly to using scouring air bubbles produced by an aeration system to clean or inhibit the fouling of membranes in a submerged membrane filter.

### BACKGROUND OF THE INVENTION

**[0002]** Submerged membranes are used to treat liquids containing solids to produce a filtered liquid lean in solids and an unfiltered retentate rich in solids. For example, submerged membranes are used to withdraw substantially clean water from wastewater and to withdraw potable water from water from a lake or reservoir.

**[0003]** The membranes are generally arranged in modules which comprise the membranes and headers attached to the membranes. The modules are immersed in a tank of water containing solids. A transmembrane pressure is applied across the membrane walls which causes filtered water to permeate through the membrane walls. Solids are rejected by the membranes and remain in the tank water to be biologically or chemically treated or drained from the tank.

**[0004]** Air bubbles are introduced to the tank through aerators mounted below the membrane modules and connected by conduits to an air blower. The air bubbles rise to the surface of the tank water and create an air lift which recirculates tank water around the membrane module. When the rate of air flow is within an effective range, the rising bubbles and tank water scour and agitate the membranes to inhibit solids in the tank water from fouling the pores of the membranes. Further, there is also an oxygen transfer from the bubbles to the tank water which, in wastewater applications; provides oxygen for microorganism growth. The air blower generally runs continuously to minimize stress on the air blower motors and to provide a constant supply of air for microorganism growth if desired.

**[0005]** With typical aeration systems, an operator increases the rate of air flow to the aerators if more cleaning is desired. This technique, however, stresses the membranes and air blower motors and increases the amount of energy used which significantly increases the operating costs of the process. Conversely, an operator typically decreases the rate of air flow to the aerators if less cleaning is desired. With this technique, however, the rate of air flow is often below the effective range, which does not provide efficient cleaning. Alternately, some operators reduce the average rate of air flow by providing air intermittently. This method allows for an air flow rate in the effective range but at the expense of the air blowers which wear rapidly when turned off and on frequently. In many cases, the warranty on the air blower is voided by such intermittent operation.

**[0006]** Another concern with typical aeration systems

is that they cause the tank water to move in a generally steady state recirculation pattern in the tank. The recirculation pattern typically includes "dead zones" where tank water is not reached by the recirculating tank water and bubbles. The membranes in these dead zones, or the parts of the membranes in these dead zones, are not effectively cleaned and may be operating in water having a higher concentration of solids than in the tank water generally. Accordingly, these membranes, or the affected parts of these membranes, quickly foul with solids.

**[0007]** A related problem occurs in modules where hollow fibre membranes are installed with a small degree of slack to allow the membranes to move and shake off or avoid trapping solids. The movement of tank water in the tank encourages slackened membranes to assume a near steady state position, particularly near the ends of the membranes, which interferes with the useful movement of the fibres.

**[0008]** Yet another concern with current aeration systems is that the aerators themselves often foul over time. Even while the air supply is on, the local air pressure near the perimeter of the aerator holes is low and often allows tank water to seep into the aerator. When aeration is stopped from time to time, for example for backwashing, cleaning or other maintenance procedures, more tank water may enter the aeration system. A portion of the tank water entering the aeration system evaporates there, leaving deposits of solids in the aeration system. In wastewater applications in particular, the deposited solids can significantly reduce the efficiency of the aeration system or cause an operator to periodically shut down filtration to clear or replace the aerators.

**[0009]** Japanese Publication Number 7-185,271 describes a filtration system having two or four membrane units separated by partitions. A blower feeds air to air dispensers located below each of the membrane units. A valve for each air dispenser is provided between the blower and each membrane unit. While filtration is stopped, the valves are opened and closed to provide 15 minutes of airflow to each of the air dispensers in turn.

**[0010]** Japanese Publication Number 8-323,161 describes a filtration system in which a flat membrane is connected to permeate outlets provided at both sides of the flat membrane. Air dispersion tubes are provided under each half of the flat membrane. The air dispersion tubes under one half of the flat membrane are connected to a blower through an electromagnetic valve. The air dispersion tubes under the other half of the flat membrane are connected to the blower through another electromagnetic valve. While withdrawing permeate from a first side of the flat membrane, bubbles are produced out of the air distribution tube below the other side of the flat membrane. After a caked layer of solids accumulates on the first side of the flat membrane, permeate withdrawal switches to the other side of the flat membrane and the first side of the flat sheet membrane is aerated until a caked layer of solids accumulates on the

second side of the flat membrane.

## SUMMARY OF THE INVENTION

**[0011]** It is an object of the present invention to provide a cyclic aeration system that may be used for aerating ultrafiltration and microfiltration membrane modules immersed in tank water in a tank. This is achieved by the cyclic aeration system defined in the independent claims. In some embodiments the system uses a valve set and a valve set controller to connect an air supply to a plurality of distinct branches of an air delivery network. The distinct branches of the air delivery network are in turn connected to aerators located below the membrane modules. While the air supply is operated to supply a steady initial flow of air, the valve set and valve set controller split and distribute the initial air flow between the distinct branches of the air distribution system so that the air flow to each distinct branch alternates between a higher flow rate and a lower flow rate in repeated cycles.

**[0012]** In one embodiment, the cyclic aeration system is used to provide intermittent aeration to membrane modules arranged in a plurality of filtration zones, each associated with a distinct branch of the air delivery network. The cyclic aeration system is configured and operated to provide aeration for a predetermined amount of time to each filtration zone in turn. In other embodiments, the cyclic aeration system is used to provide intense aeration to a group of membrane modules. In one such embodiment, the cyclic aeration system is configured and operated to provide air to a branch of the air delivery network alternating between a higher flow rate and a lower flow rate in cycles of 120 seconds or less. In another such embodiment, aerators associated with a first branch of the air delivery network are interspersed with aerators associated with a second branch of the air delivery network. Air flow at a higher flow rate is alternated between the first and second branches of the air delivery network in cycles of 120 seconds or less.

## BRIEF DESCRIPTION OF THE DRAWINGS

**[0013]** Preferred embodiments of the present invention will now be described with reference to the following figures.

Figure 1A is a schematic drawing of a submerged membrane reactor.

Figures 1B, 1C and 1D are drawings of membrane modules according to embodiments of the present invention.

Figure 2 is a plan view schematic of an aeration system according to an embodiment of the present invention.

Figure 3 is a series of graphs showing the effect of operating an embodiment of the present invention.

Figures 4A, 4B, and 4C are schematic drawings of valve sets and valve controllers according to embodiments of the invention.

Figure 5 is a plan view schematic of membrane modules and an aeration system according to an embodiment of the invention.

Figure 6 is a plan view schematic of membrane modules and an aeration system according to another embodiment of the invention.

Figure 7A is a plan view schematic of membrane modules and an aeration system according to another embodiment of the invention.

Figures 7B, 7C and 7D are elevational representations of membrane modules and parts of an aeration system according to alternatives to the embodiment of Figure 7A.

Figures 8A and 8B are elevational representations of membrane modules and parts of an aeration system according to an embodiment of the invention under the influence of a cyclic aeration system.

Figures 9A, 9B, 9C and 9D are drawings of aerators according to an embodiment of the invention.

Figures 10A, 10B and 10C are charts showing the results of tests performed on embodiments of the invention having two groups of aerators.

Figure 11 is a chart showing the results of tests performed on embodiments of the invention having a single group of aerators.

## DETAILED DESCRIPTION OF EMBODIMENTS

### General Description

**[0014]** Referring now to Figure 1A, the general arrangement of a reactor 10 is shown. The description of the reactor 10 in this section applies generally to various embodiments to be described below to the extent that it is not inconsistent with the description of any particular embodiment.

**[0015]** The reactor 10 has a tank 12 which is initially filled with feed water 14 through an inlet 16. The feed water 14 may contain microorganisms, suspended solids or other matter which will be collectively called solids. Once in the tank, the feed water 14 becomes tank water 18 which may have increased concentrations of the various solids, particularly where the reactor 10 is used to treat wastewater.

**[0016]** One or more membrane modules 20 are mounted in the tank and have one or more headers 22 in fluid communication with a permeate side of one or more membranes 6. The membranes 6 in the membrane modules 20 have a pore size in the microfiltration or ultrafiltration range, preferably between 0.003 and 10 microns.

**[0017]** Membrane modules 20 are available in various sizes and configurations with various header configurations. For example, the membranes 6 may be hollow fibres potted in one or more headers 22 such that the lumens of the hollow fibres are in fluid communication with at least one header 22. The headers 22 may be of any convenient shape but typically have a rectangular or round face where they attach to the membranes 6. Alternatively, the membranes 6 may be flat sheets which are typically oriented vertically in a spaced apart pair with headers 22 on all four sides in fluid communication with the resulting interior surface. A membrane module 20 may have one or more microfiltration or ultrafiltration membranes 6 and many membrane modules 20 may be joined together to form larger membrane modules, or cassettes, but all such configurations will be referred to as membrane modules 20.

**[0018]** Figures 1B, 1C and 1D illustrate preferred membrane modules 20 having rectangular skeins 8. In each rectangular skein 8, hollow fibre membranes 23 are held between two opposed headers 22. The ends of each membrane 23 are surrounded by potting resin to produce a watertight connection between the outside of the membrane 23 and the headers 22 while keeping the lumens of the hollow fibre membranes 23 in fluid communication with at least one header 22. The rectangular skeins 8 may be oriented in a horizontal plane (Figure 1B), vertically (Figure 1C) or horizontally in a vertical plane (Figure 1D). A plurality of rectangular skeins 8 are typically joined together in a membrane module 20.

**[0019]** Although a single row of hollow fibre membranes 23 is illustrated in each rectangular skein 8, a typical rectangular skein 8 has a mass of hollow fibre membranes 23 between 2 cm and 10 cm wide. The hollow fibre membranes 23 typically have an outside diameter between 0.4 mm and 4.0 mm and are potted at a packing density between 10% and 40%. The hollow fibre membranes 23 are typically between 400 mm and 1,800 mm long and mounted with between 0.1% and 5% slack.

**[0020]** Referring again to Figure 1A, the tank 12 is kept filled with tank water 18 above the level of the membranes 6 in the membrane modules 20 during permeation. Filtered water called permeate 24 flows through the walls of the membranes 6 in the membrane modules 20 under the influence of a transmembrane pressure and collects at the headers 22 to be transported to a permeate outlet 26 through a permeate line 28. The transmembrane pressure is preferably created by a permeate pump 30 which creates a partial vacuum in a permeate line 28. The transmembrane pressure may vary for dif-

ferent membranes and different applications, but is typically between 1 kPa and 150 kPa. Permeate 24 may also be periodically flowed in a reverse direction through the membrane modules 20 to assist in cleaning the membrane modules 20.

**[0021]** During permeation, the membranes 6 reject solids which remain in the tank water 18. These solids may be removed by a number of methods including digestion by microorganisms if the reactor 10 is a bioreactor or draining the tank 12 periodically or by continuously removing a portion of the tank water 18, the latter two methods accomplished by opening a drain valve 32 in a drain conduit 34 at the bottom of the tank.

**[0022]** An aeration system 37 has one or more aerators 38 connected by an air delivery system 40 and a distribution manifold 51 to an air source 42, which is typically one or more air blowers, and produces bubbles 36 in the tank water. The aerators 38 may be of various types including distinct aerators, such as cap aerators, or simply holes drilled in conduits attached to or part of the distribution manifold 51. The bubbles 36 are preferably made of air but may be made of other gasses such as oxygen or oxygen enriched air if required.

**[0023]** The aerators 38 are located generally below the membrane modules 20. If the membrane modules 20 are made of rectangular skeins 8 having vertical hollow fibre membranes 23, the aerators 38 are preferably located to produce bubbles near the edges of the lower header. With rectangular skeins 8 having hollow fibre membranes 23 in a vertical plane, the aerators 38 are preferably located to produce bubbles in a line directly below the vertical plane. With rectangular skeins 8 having hollow fibre membranes 23 in a horizontal plane, the aerators 38 are preferably located to produce bubbles evenly dispersed below the plane.

**[0024]** The bubbles 36 agitate the membranes 6 which inhibits their fouling or cleans them. In addition, the bubbles 36 also decrease the local density of tank water 18 in or near the membrane modules 20 which creates an air-lift effect causing tank water 18 to flow upwards past the membrane modules 20. The air lift effect causes a recirculation pattern 46 in which the tank water 18 flows upwards through the membrane modules 20 and then downwards along the sides or other parts of the tank. The bubbles 36 typically burst at the surface and do not generally follow the tank water 18 through the downward flowing parts of the recirculation pattern 46. The tank water 18 may also flow according to, for example, movement from the inlet 16 to the drain conduit 34, but such flow does not override the flow produced by the bubbles 36.

**[0025]** The bubbles 36 have an average diameter between .1 and 50 mm. Individual large bubbles 36 are believed to be more effective in cleaning or inhibiting fouling of the membranes 6, but smaller bubbles 36 are more efficient in transferring oxygen to the tank water 18 and require less energy to produce per bubble 36. Bubbles 36 between 3 mm and 20 mm, and more pref-

erably between 5 mm and 15 mm in diameter, are suitable for use in many wastewater applications. Bubbles 36 in the ranges described immediately above provide effective cleaning of the membranes 6 and acceptable transfer of oxygen to the tank water 18 without causing excessive foaming of the tank water 18 at the surface of the tank 12. If the reactor 10 is used to create potable water or for other applications where oxygen transfer is not required, then bubbles between 5 mm and 25 mm are preferred.

**[0026]** The bubbles 36 may be larger than a hole in an aerator 38 where the bubble 36 is created according to known factors such as air pressure and flow rate and the depth of the aerators 38 below the surface of the tank water 18. If the aerators 38 are located near the bottom of a large tank 12, such as those used in municipal treatment works, an aerator 38 with holes of between 2 mm and 15 mm and preferably between 5 mm and 10 mm might be used. The air pressure supplied (relative to atmospheric pressure) is typically determined by the head of water at the depth of submergence of the aerators 38 (approximately 10 kPa per metre) plus an additional pressure required to get the desired rate of air flow through the aerators 38. There is a typically a pressure drop of between 5 mm and 100 mm of water, and more typically between 10 mm and 50 mm of water, across the holes of the aerators 38. Parts of the aeration system 37 located at a distance below the bottom of the holes of the aerators 38 equal to the pressure drop are generally free of tank water when the air source 42 is operating, although small amounts of tank water 18 may still seep into the aeration system 37.

#### *Cyclic Aeration System*

**[0027]** Now referring to Figure 2 a cyclic aeration system 237 is shown having an air supply 242 in fluid communication with a valve set 254, the valve set 254 controlled by a valve controller 256. The valve set 254 is in fluid communication with an air delivery network 240 having a plurality of distinct branches each in fluid communication with distinct manifolds 251 in fluid communication with conduit aerators 238. Other types of aerators may also be used with suitable modifications to the manifolds 251 or air delivery network, but conduit aerators 238 are preferred. The third branch of the air delivery network 240 and the third manifold 251 are shown in dashed lines to indicate that the number of distinct branches of the air delivery network 240 and manifolds 251 may be two or more, but preferably not more than 15.

**[0028]** The air supply 242 is a source of pressurized air, typically one or more air blowers, and provides a flow of a gas at an initial rate to the cyclic aeration system. The gas is most often air, but may also be oxygen, oxygen or ozone enriched air, or nitrogen in which cases the air supply 242 will include oxygenation or ozonation equipment etc. in addition to an air blower. In this doc-

ument, however, the term "air" will be used to refer to any appropriate gas. The amount of air provided by the air supply 242 is best determined by summing the amount of air provided to all conduit aerators 238 (to be described below) serviced by the air supply 242. It is preferred that the air supply 242 supply a constant amount of air over time.

**[0029]** The valve set 254 and valve controller 256 will be described in more detail below. In general terms, however, the valve set 254 and valve controller 256 (a) split the air flow from the air supply 242 between the branches of the air delivery network 240 such that, at a point in time, some of the branches receive air at a higher rate of air flow and some of the branches receive air at a lower rate of air flow and (b) switch which branches of the air delivery network 240 receive the higher and lower rates of air flow in repeated cycles.

**[0030]** An example is illustrated in Figure 3. In each of parts a), b), and c) of Figure 3, Rh indicates a higher rate of air flow; Rl indicates a lower rate of air flow; and, the time from 0 to t3 indicates a cycle which would be repeated. The cycle is divided into three substantially equal time periods, 0-t1; t1 - t2; and, t2 - t3. In each of these periods, one branch of the air delivery system 240 and its associated manifold 251 receive air at Rh while the others receive air at Rl. Similarly, each branch of the air delivery system 240 and its associated manifold 251 receives air at Rh for one third of the cycles and at Rl for two thirds of the cycle.

**[0031]** Many of the valve sets 254 to be described below can be used to produce smooth variations in air flow rate to a manifold 251, but it is preferred if the variation is fairly abrupt as suggested by Figure 3. The inventors have noticed that such an abrupt change produces a short burst of unusually large bubbles 36 which appear to have a significant cleaning or fouling-inhibiting effect. The abrupt changes often also produces a spike in air flow rate shortly after the transition from Rl to Rh which produces a corresponding pressure surge. This pressure surge must be kept within the design limits of the cyclic aeration system 237 or appropriate blow-off valves etc. provided.

**[0032]** The amount of air provided to a manifold 251 or branch of air delivery network 240 is dependent on numerous factors but is preferably related to the superficial velocity of air flow for the conduit aerators 238.

**[0033]** The superficial velocity of air flow is defined as the rate of air flow to the conduit aerators 238 at standard conditions (1 atmosphere and 25 degrees Celsius) divided by the cross sectional area of aeration. The cross sectional area of aeration is determined by measuring the area effectively aerated by the conduit aerators 238. Superficial velocities of air flow of between 0.013 m/s and 0.15 m/s are preferred at the higher rate (Rh). Air blowers for use in drinking water applications may be sized towards the lower end of the range while air blowers used for waste water applications may be sized near the higher end of the range.

[0034] R1 is typically less than one half of Rh and is often an air off condition with no flow. Within this range, the lower rate of air flow is influenced by the quality of the feed water 14. An air off condition is generally preferred, but with some feed water 14, the hollow fibre membranes 23 foul significantly even within a short period of aeration at the lower rate. In these cases, better results are obtained when the lower rate of air flow approaches one half of the higher rate.

[0035] Referring now to Figures 4A, 4B and 4C, alternative embodiments of the valve set 254 and valve controller 256 are shown. In Figure 4A, an air supply 242 blows air into a three-way valve 292, preferably a ball valve, with its two remaining orifices connected to two manifolds 251. A three way valve controller 294 alternately opens an air pathway to one of the manifolds 251 and then the other. Preferably there is a phase shift of 180 degrees so that the air pathway to one of the manifolds 251 opens while the airway to the other manifold 251 closes. The three-way valve 292 may be mechanically operated by handle 296 connected by connector 298 to a lever 299 on the three-way valve controller 294 which is a drive unit turning at the required speed of rotation of the lever 299. Preferably, however, the three way valve controller 294 is a microprocessor and servo or solenoid combination which can be more easily configured to abruptly move the three way valve 292.

[0036] In Figure 4B, the air supply 242 blows air into a connector 261 which splits the air flow into a low flow line 262 and a high flow line 264. A valve 266 in the low flow line 262 is adjusted so that flow in the low flow line 262 is preferably less than one half of the flow in the high flow line 264. A controller 268, preferably a timer, a microprocessor or one or more motors with electrical or mechanical links to the valves to be described next, controls a low valve 270, which may be a solenoid valve or a 3 way ball valve, and a high valve 272, which may be a solenoid valve or a 3 way ball valve, so that for a first period of time (a first part of a cycle) air in the low flow line 262 flows to one of the manifolds 251 and air in the high flow line flows to the other manifold 251. For a second period of time (a second part of a cycle), the low valve 270 and high valve 272 are controlled so that air in the low flow line 262 flows to the a manifold 251 through cross conduit 274 and air in the high flow line 264 flows to the other manifold 251 through reverse conduit 276.

[0037] In Figure 4C, air supply 242 blows air into a blower header 260 connected by slave valves 284 to manifolds 251. Each valve 284 is controlled by a slave device 280, typically a solenoid or a servo motor. The slave devices are operated by a microprocessor 282 programmed to open and close the slave valves 284 in accordance with the system operation described in this section and the embodiments below.

#### *Use of Cyclic Aeration to Provide Efficient Intermittent Aeration*

[0038] Use of the cyclic aeration system 237 to provide efficient intermittent aeration will now be described with reference to the following embodiment, it being understood that the invention is not limited to the embodiment. Referring to Figure 5, an aeration system 237 is shown for use in providing intermittent aeration to six membrane modules 20 (shown with dashed lines) in a filtration tank 412. The filtration tank 412 has six filtration zones (also shown with dashed lines) corresponding to the six membrane modules 20. Alternatively, the filtration zones could be provided in separate tanks with one or more membrane modules 20 in each tank. The membrane modules 20 will be used to filter a relatively foulant free surface water such that intermittent aeration is suitable.

[0039] The air delivery network 240 has six distinct branches each connected to a header 251 in a filtration zone. Each header 251 is in turn connected to conduit aerators 238 mounted generally below the membrane modules 20. The valve set 254 and valve controller 256 are configured and operated to provide air from the air supply 242 to the air delivery network 240 in a 7.5 minute cycle in which air at the higher rate is supplied for about 75 seconds to each branch of the air delivery network 240 in turn. While a branch of the air delivery network 240 is not receiving air at the higher rate, it receives air at the lower rate. Accordingly, each header 251 receives air at the higher rate for 75 seconds out of every 7.5 minutes. Operation of the air supply 242, however, is constant and an air supply sized for one manifold 251 is used to service six such manifolds.

[0040] It is preferable if backwashing of the membrane modules 20 is also performed on the membrane modules in turn such that backwashing of a membrane module 20 occurs while the membrane module 20 is being aerated. The membrane modules 20 can be backwashed most easily when each membrane module 20 is serviced by its own permeate pump 30 and associated backwashing apparatus. In large municipal systems, for example, the permeation and backwashing apparatus are typically limited to about 8 to 11 ML/d capacity. Accordingly a medium size plant (ie. in the range of 40 ML/d) will have several membrane modules 20 serviced by sets of permeation and backwashing apparatus which can be individually controlled. In some plants, backwashing is performed on the membrane modules 20 in turn to produce an even supply of permeate 24 regardless of aeration.

[0041] In a pilot study conducted with feed water having turbidity of .3 ntu and colour of 3.9 tcu, for example, the inventors were able to achieve acceptable sustained permeability of a membrane module using 75 seconds of aeration at a higher rate of .035 m/s superficial velocity every 15 minutes and 15 seconds. For the remainder of the cycle there was no aeration. Each cycle involved

15 minutes of permeation through the membrane modules 20 and 15 seconds of backwashing. The 75 seconds of aeration was timed so that there was 30 seconds of aeration before the backpulse, aeration during the backpulse, and 30 seconds of aeration after the backpulse. The test suggests that if cycled aeration is timed to coincide for each manifold 251 with the backwashing of the associated membrane module 20, then about 12 membrane modules 20 could be serviced by a single air supply 242 as part of the cyclic aeration system 237.

#### *Use of Cyclic Aeration to Provide Intense Aeration*

**[0042]** Use of the cyclic aeration system 237 to provide intense aeration will now be described with reference to the following embodiment, it being understood that the invention is not limited to the embodiment. Referring to Figure 6, an aeration system 237 is shown for use in providing aeration alternating between two sets of membrane modules 20 (shown with dashed lines) in a filtration vessel 512. The filtration vessel 512 has two filtration zones (also shown with dashed lines) corresponding to the two sets of membrane modules 20. Alternately, the filtration zones could be provided in separate tanks with one or more membrane modules 20 in each tank. The membrane modules 20 will be used to filter a relatively foulant-rich surface water or a wastewater such that intense aeration is suitable.

**[0043]** The air delivery network 240 has two distinct branches each connected to headers 251 in a filtration zone. Each header 251 is in turn connected to conduit aerators 238 mounted generally below the membrane modules 20. The valve set 254 and valve controller 256 are configured and operated to provide air from the air supply 242 to the air delivery network 240 in a short cycle in which air at the higher rate is supplied for one half of the cycle to each branch of the air delivery network 240. While a branch of the air delivery network 240 is not receiving air at the higher rate, it receives air at the lower rate.

**[0044]** The preferred total cycle time may vary with the depth of the filtration vessel 512, the design of the membrane modules 20, process parameters and the conditions of the feed water 14 to be treated, but preferably is at least 10 seconds (5 seconds at the full rate and 5 seconds at the reduced rate) where the filtration vessel 512 is a typical municipal tank between 1 m and 10 m deep. A cycle time of up to 120 seconds (60 seconds at the full rate, 60 seconds at the reduced rate) may be effective, but preferably the cycle time does not exceed 60 seconds (30 seconds at the full rate, 30 seconds at the reduced rate) where the filtration vessel 512 is a typical municipal tank.

**[0045]** The inventors believe that such rapid cycling creates transient flow within the tank water 18. In particular, an air lift effect is created or strengthened when the rate of airflow changes from R1 to Rh causing the tank water 18 to accelerate. Shortly afterwards, howev-

er, aeration and the air lift effect are sharply reduced causing the tank water 18 to decelerate. With very short cycles, the tank water 18 is accelerating or decelerating for much of the cycle and is rarely in a steady state. It is believed that formation of quiescent zones in the tank water 18 is inhibited and that beneficial movement of the hollow fibre membranes 23 is enhanced. For example, horizontal hollow fibre membranes 23, as shown in the rectangular skeins 8 of Figures 1B and 1D, assume a generally concave downward shape under steady state aeration and experience limited movement at their ends. With cyclic aeration as described above, however, tension in the hollow fibre membranes 23 is released cyclically and, in some cases, local currents which flow downward may be created for brief periods of time. The ends of the horizontal hollow fibre membranes 23 experience more beneficial movement and foul less rapidly. Since the beneficial effects may be linked to creating transient flow, it is also believed that factors which effect acceleration of the water column above a set of conduit aerators 238, such as tank depth or shrouding, could modify the preferred cycle times stated above.

#### *Use of Cyclic Aeration to Promote Horizontal Flow*

**[0046]** Use of the cyclic aeration system 237 to promote horizontal flow in the tank water 18 will now be described with reference to the following embodiment, it being understood that the invention is not limited to the embodiment. Referring to Figure 7A, an aeration system 237 is shown for use in aerating membrane modules 20 in a process tank 612. The membrane modules 20 will be used to filter a relatively foulant-rich surface water or a wastewater such that intense aeration is suitable.

**[0047]** The air delivery network 240 has two distinct branches each connected to two distinct headers 251, both in a single filtration zone. The headers 251 will be referred to as header 251a and 251b where convenient to distinguish between them. Headers 251 are connected to conduit aerators 238 such that the conduit aerators 238 attached to header 251a are interspersed with the conduit aerators 238 attached to header 251b. One such arrangement is shown in Figure 7A in which header 251a is connected to conduit aerators 238 directly beneath the membrane modules 20 while header 251b is connected to horizontally displaced conduit aerators 238 located beneath and between the membrane modules 20. Referring now to Figures 7B, 7C and 7D, a set of variations of the embodiment of Figure 7A is shown. In Figure 7B, header 251a and header 251b are connected to alternating horizontally displaced conduit aerators 238 located beneath the membrane modules 20. In Figure 7C, header 251a and header 251b are connected to alternating horizontally displaced conduit aerators 238 located directly beneath alternating membrane modules 20. In Figure 7C, header 251a and header 251b are connected to alternating horizontally dis-

placed conduit aerators 238 located directly beneath and between alternating membrane modules 20. In each of these cases, the pattern may be repeated where more membrane modules 20 are used.

**[0048]** Each of header 251a and header 251b is connected to a distinct branch of the air delivery network 240 in turn connected to a valve set 254. The valve set 254 and a valve controller 256 are configured and operated to provide air from an air supply 242 to the air delivery network 240 in a short cycle in which air at a higher rate is supplied for one half of the cycle to each branch of the air delivery network 240. While a branch of the air delivery network 240 is not receiving air at the higher rate, it receives air at the lower rate. The lower flow rate is preferably one half or less of the higher flow rate and, where conditions allow it, the lower flow rate is preferably an air-off condition.

**[0049]** The total cycle time may vary with the depth of the process tank 612 the design of the membrane modules 20, process parameters and the conditions of the feed water 14 to be treated, but preferably is at least 2 seconds (1 second at the full rate and 1 second at the reduced rate) and less than 120 seconds (60 seconds at the full rate, 60 seconds at the reduced rate) where the process tank 612 is a typical municipal tank between 1 m and 10 m deep. Preferably, however, the cycle time is between 20 seconds and 40 seconds in length. Short cycles of 10 seconds or less may not be sufficient to establish regions of different densities in the tank water 18 in a deep tank 12 where such time is insufficient to allow the bubbles 36 to rise through a significant distance relative to the depth of the tank 12. Long cycles of 120 seconds or more may result in parts of a membrane module 20 not receiving bubbles 36 for extended periods of time which can result in rapid fouling. As discussed above, the beneficial effects of the invention may be linked to creating transient flow and it is believed that factors which effect acceleration of the water column above a set of conduit aerators 238, such as tank depth or shrouding, could modify the preferred cycle times stated above.

**[0050]** In this embodiment, having the conduit aerators 238 connected to header 251a interspersed with the conduit aerators 238 attached to header 251b creates varying areas of higher and lower density in the tank water 18 within a filtration zone. As described above, the inventors believe that these variations produce transient flow in the tank water 18. Where the effective areas of aeration above conduit aerators 238 attached to distinct branches of the air delivery network 240 are sufficiently small, however, the inventors believe that appreciable transient flow is created in a horizontal direction between areas above conduit aerators 238 attached to different branches of the air delivery network 240. Referring to Figures 7A, 7B, 7C, 7D the membrane modules 20 shown are preferably of the size of one or two rectangular skeins 8.

**[0051]** As an example, in Figures 8A and 8B mem-

brane modules 220 made of rectangular skeins 8 with hollow fibre membranes 23 oriented vertically aerated by a cyclic aeration system 237 with conduit aerators 238 located relative to the membrane modules 220 as shown in Figure 7D. In Figures 8A and 8B, the degree of slack of the hollow fibre membranes 23 is highly exaggerated for easier illustration. Further, only two hollow fibre membranes 23 are illustrated for each vertical rectangular skein 8 although, as discussed above, a rectangular skein 8 would actually be constructed of many hollow fibre membranes 23.

**[0052]** With steady state aeration, it is difficult to encourage bubbles 36 to penetrate the vertical rectangular skeins 8. The natural tendency of the bubbles 36 is to go through the areas with lowest resistance such as around the membrane modules 220 or through slots between the membrane modules 220 and the hollow fibre membranes 23 on the outer edge of the vertical rectangular skeins 8 may have significantly more contact with the bubbles 36. Further, the upper 10-20% of the hollow fibre membranes 23 is often forced into a tightly curved shape by the air lift effect and moves only very little. A smaller portion at the bottom of the hollow fibre membranes 23 may also be tightly curved by the current travelling around the lower header 22. In these tightly curved areas, the hollow fibre membranes 23 foul more rapidly.

**[0053]** With cyclic aeration, however, air at the higher rate is alternated between header 251a and header 251b. When more air is supplied to header 251a, the hollow fibre membranes 23 assume an average shape as shown in Figure 8A with a first local recirculation pattern 380 as shown. When more air is supplied to header 251b, the hollow fibre membranes 23 assume an average shape as shown in Figure 8B with a second local recirculation pattern 382 as shown. Under the influence of a cyclic aeration system 237, the hollow fibre membranes 23 alternate between the positions shown in Figures 8A and 8B. Accordingly, the portion of the hollow fibre membranes 23 which moves only very little is decreased in size. The cycling also creates a reversing flow into and out of the vertical rectangular skeins 8 which the inventors believe encourages bubbles 36 to penetrate deeper into the vertical rectangular skeins 8.

#### 45 *Conduit Aerators*

**[0054]** Now referring to Figure 9A, a conduit aerator 238 is shown. The conduit aerator 238 has an elongated hollow body 302 which is a circular pipe having an internal diameter between 15 mm and 100 mm. A series of holes 304 pierce the body 302 allowing air to flow out of the conduit aerator 238 to create bubbles. The size, number and location of holes may vary but for a rectangular skein 8, for example, 2 holes (one on each side) of between 5 mm and 10 mm in diameter placed every 50 mm to 100 mm along the body 302 and supplied with an airflow which results in a pressure drop through the holes of between 10 to 100 mm of water at the depth of



the conduit aerator 238 are suitable.

[0055] Air enters the conduit aerator 238 at an aerator inlet 306. At the opposite end of the conduit aerator 238 is an outlet 308. The highest point on the outlet 308 is located below the lowest point on the aerator inlet 306 by a vertical distance between the minimum and maximum expected pressure drop of water at the depth of the conduit aerator 238 across the holes 304. The minimum expected pressure drop of water at the depth of the conduit aerator 238 across the holes 304 is preferably at least as much as the distance between the top of the holes 304 and the interior bottom of the body 302. An air/water interface 309 between the air in the conduit aerator 238 and the water surrounding the conduit aerator 238 will be located below the interior bottom of the body 302 but above the highest point on the outlet 308. In this way, tank water 18 entering the conduit aerator 238 will flow to the outlet 308 and not accumulate near the holes 304.

[0056] Now referring to Figure 9B, another conduit aerator 238 is shown which is preferred for use with relatively clean tank water 18. The body 302 has a rectangular cross section but is open on the bottom. The conduit aerator 238 may be a separate component or integrated into the headers 22 of a membrane module 20 in which case the bottom of a lower header 22 may serve as the top of the body 302. The end of the body 302 is capped with a cap 310 which again may be a part of a header 22. With the bottom of the body 302 open to the tank water 18, tank water 18 which seeps into the conduit aerator 238 flows back to the tank water 18. To prevent bubbles 36 from forming at the bottom of the conduit aerator 238, the sides of the body 302 extend below the bottom of the holes 304 by a distance greater than the expected pressure drop through the holes 304.

[0057] Now referring to Figure 9C, another conduit aerator 238 is similar to the conduit aerator 238 of Figure 9A except as will be described herein. A rubber sleeve 400, shown partially cut away, covers the body 302 and has slits 402 corresponding with the holes 304. The slits 402 open when air is flowed into the conduit aerator 238 opening to a larger size when a higher rate of air flow is used. Accordingly, the slits 402 produce larger bubbles 36 at the full rate of air flow and smaller bubbles 36 at the reduced rate of air flow. In wastewater applications, the reduced size of the bubbles 36 provides improved oxygen transfer efficiency at the reduced rate of air flow.

[0058] Now referring to Figure 9D, another conduit aerator is shown which is preferred for use with relatively solids-rich tank water 18. The body 302 is a tube 32 mm in diameter. The holes 304 are 8 mm in diameter and mounted 30 degrees upwards of horizontal. Drainage holes 410, at the bottom of the body 302 and typically 16 mm in diameter, allow tank water 18 seepage to drain from the body 302. A cap 411 covers the end of the body 302.

[0059] Conduit aerators 238 such as those described above may admit some tank water 18, even with air flow-

ing through them, which dries out leaving an accumulation of solids. When the supply of air is switched between manifolds as described above, however, the conduit aerator 238 is alternately flooded and emptied. The resulting cyclical wetting of the conduit aerators 238 helps re-wet and remove solids accumulating in the conduit aerators 238 or to prevent tank water 18 from drying and depositing solids in the conduit aerators 238. If necessary, this flooding can be encouraged by releasing air from the appropriate manifold by opening a valve vented to atmosphere.

[0060] Embodiments similar to those described above can be made in many alternate configurations and operated according to many alternate methods within the teachings of the invention, the scope of which is defined in the following claims.

#### Examples

[0061] The following examples refer to ZW 500 membrane modules produced by ZENON Environmental Inc.. Each ZW 500 has two rectangular skeins of vertical hollow fiber membranes. For the purposes of calculating superficial velocities, the cross sectional area of aeration for each ZW 500 membrane module is approximately 0.175 m<sup>2</sup>. All air flow rates given below are at standard conditions.

#### Example 1

[0062] A cassette of 8 ZW 500 membrane modules were operated in bentonite suspension under generally constant process parameters but for changes in flux and aeration. A fouling rate of the membranes was monitored to assess the effectiveness of the aeration. Aeration was supplied to the cassette at constant rates of 204 m<sup>3</sup>/h (ie. 25.5 m<sup>3</sup>/h per module) and 136 m<sup>3</sup>/h and according to various cycling regimes. In the cycled tests, a total air supply of 136 m<sup>3</sup>/h was cycled between aerators located below the modules and aerators located between and beside the modules in cycles of the durations indicated in Figure 10A. Aeration at 136 m<sup>3</sup>/h in 30 second cycles (15 seconds of air to each set of aerators) was approximately as effective as non-cycled aeration at 204 m<sup>3</sup>/h.

#### Example 2

[0063] The same apparatus as described in example 1 was tested under generally constant process parameters but for the variations in air flow indicated in Figure 10B. In particular, 70% of the total air flow of 136 m<sup>3</sup>/h was cycled in a 20 second cycle such that each group of aerators received 70% of the total airflow for 10 seconds and 30% of the total airflow for 10 seconds. As shown in Figure 10B, cycling 70% of the air flow resulted in reduced fouling rate at high permeate flux compared to constant aeration at the same total air flow.

## Example 3

**[0064]** 2 ZW 500 membrane modules were operated to produce drinking water from a natural supply of feed water. Operating parameters were kept constant but for changes in aeration. The modules were first operated for approximately 10 days with non-cycled aeration at 25.5 m<sup>3</sup>/h per module (for a total system airflow 51 m<sup>3</sup>/h). For a subsequent period of about three days, air was cycled from aerators near one set of modules to aerators near another set of modules such that each module was aerated at 12.8 m<sup>3</sup>/h for 10 seconds and then not aerated for a period of 10 seconds (for a total system airflow of 12.8 m<sup>3</sup>/h). For a subsequent period of about 10 days, the modules were aerated such that each module was aerated at 25.5 m<sup>3</sup>/h for 10 seconds and then not aerated for a period of 10 seconds (for a total system airflow of 25.5 m<sup>3</sup>/h). For a subsequent period of about 10 days, the initial constant airflow was restored. As shown in Figure 10C, with aeration such that each module was aerated at 25.5 m<sup>3</sup>/h for 10 seconds and then not aerated for a period of 10 seconds (ie. one half of the initial total system airflow), the membrane permeability stabilized at over 250 L/m<sup>2</sup>/h/bar whereas with non-cycled airflow at the initial total system airflow the membrane permeability stabilised at only about 125 L/m<sup>2</sup>/h/bar.

## Example 4

**[0065]** 3 units each containing 2 ZW 500 membrane modules were operated at various fluxes in a membrane bioreactor. Unit 1 had modules operating at 26 L/m<sup>2</sup>/h and 51 L/m<sup>2</sup>/h. Unit 2 had modules operating at 31 L/m<sup>2</sup>/h and 46 L/m<sup>2</sup>/h. Unit 3 had modules operating at 34 L/m<sup>2</sup>/h and 51 L/m<sup>2</sup>/h. The units were first operated for a period of about 10 days with non-cycled aeration at 42.5 m<sup>3</sup>/h per module (total system air flow of 85 m<sup>3</sup>/h). The permeability decreased and stabilized at between 250 and 275 L/m<sup>2</sup>/h/bar for Unit 1, between 200 and 225 L/m<sup>2</sup>/h/bar for Unit 2 and between 150 and 175 L/m<sup>2</sup>/h/bar for Unit 3. For a second period of about 14 days, a total system airflow of 61.2 m<sup>3</sup>/h was applied for 10 seconds to aerators below the modules and then for 10 seconds to aerators beside the modules. Under these conditions, permeability increased and stabilized at between 350 and 375 L/m<sup>2</sup>/h/bar for Unit 1 and between 325 and 350 L/m<sup>2</sup>/h/bar for Units 2 and 3.

## Example 5

**[0066]** A cassette of 6 ZW 500 modules was used to treat sewage. While holding other process parameters generally constant, aeration was varied and permeability of the modules was measured periodically as shown in Figure 11. In period A, 255 m<sup>3</sup>/h of air was supplied continuously and evenly to the modules. In period B, 184 m<sup>3</sup>/h of air was applied for 10 seconds to aerators below the modules and then for 10 seconds to aerators beside

the modules. In Period C, the same aeration regime was used, but shrouding around the modules was altered. In period D, 184 m<sup>3</sup>/h of air was applied for 10 seconds to aerators near a first set of modules and then for 10 seconds to aerators near a second set of modules. In period E, 204 m<sup>3</sup>/h of air was applied to all of the modules evenly for 10 seconds and then no air was supplied to the modules for 10 seconds. In Period F, 306 m<sup>3</sup>/h was applied to all of the modules evenly for 10 seconds and then no air was supplied to the modules for 10 seconds. In Period G, 153 m<sup>3</sup>/h was applied to aerators near a first set of modules and then for 10 seconds to aerators near a second set of modules.

## Example 6

**[0067]** A single ZW 500 membrane module was used to filter a supply of surface water. While keeping other process parameters constant, the module was operated under various aeration regimes and its permeability recorded periodically. First the module was operated with constant aeration at (a) 20.4 m<sup>3</sup>/h and (b) 25.5 m<sup>3</sup>/h. After an initial decrease in permeability, permeability stabilised at (a) about 200 L/m<sup>2</sup>/h/bar and (b) between 275 and 300 L/m<sup>2</sup>/h/bar respectively. In a first experiment, aeration was supplied to the module at 25.5 m<sup>3</sup>/h for two minutes and then turned off for 2 minutes. In this trial, permeability decreased rapidly and could not be sustained at acceptable levels. In another experiment, however, aeration was supplied to the module at 25.5 m<sup>3</sup>/h for 30 seconds and then at 8.5 m<sup>3</sup>/h for 30 seconds. In this trial, permeability again decreased initially but then stabilised at between 275 and 300 L/m<sup>2</sup>/h/bar.

## Claims

1. A device for aerating one or more membrane modules (20) immersed in tank water (18) in a tank (12; 412; 512; 612), having:

- (a) a gas delivery network (40; 240);
- (b) one or more aerators (38; 238) in fluid communication with the gas delivery network and mounted so as to be effective to clean or inhibit fouling of the membrane module;
- (c) a gas supply (42; 242) adapted to provide an initial gas flow at an initial flow rate; and
- (d) one or more valves in a valve set (254) in fluid communication with the gas supply (42; 242) and having an outlet in fluid communication with the gas delivery network (240);

**characterized in that** the device also includes:-

- (e) a valve set controller (256) mechanically or electrically linked to the valve set (254), which automatically operates the or each valve so that

- the aerator(s) (38; 238) receive gas at a rate switching between a higher flow rate and a lower flow rate, the lower flow rate being less than half the higher flow rate, in repeated cycles of not more than 120 seconds in duration. 5
2. A device according to claim 1, wherein the gas delivery network (240) has a plurality of distinct branches, each branch being in communication with one or more aerators mounted below the membrane module(s) (20), and the controller splits the gas flow between the distinct branches so that each distinct branch receives a supply of gas switching between the higher flow rate and the lower flow rate. 10
3. A device according to claim 2, in which, while the gas supply provides an essentially constant initial flow, the switching between high and low rates in the branches is carried out in such a way that the total gas flow is essentially constant while aeration is performed. 15 20
4. A device according to claim 2 or 3, in which the aerators (238) associated with a first distinct branch of the gas delivery network (240) are interspersed in a horizontal plane with the aerators (238) associated with a second distinct branch of the gas delivery network (240) in such a way that adjacent aerators (238) are in fluid connection with different distinct branches of the gas delivery network (240). 25 30
5. A device according to any preceding claim, wherein the repeated cycles are between 20 seconds and 60 seconds in duration, in particular between 20 seconds and 40 seconds in duration. 35
6. A device according to any preceding claim, wherein the membrane modules (20) have rectangular skeins (8) of vertically oriented hollow fibre membranes (23) between upper and lower headers (251), the aerators (38; 238) are conduit aerators approximately as long as the headers (251) of the rectangular skeins (8) and the aerators (38; 238) are mounted parallel to the headers (251) of the rectangular skeins (8). 40 45
7. A device according to any preceding claim, wherein the gas supply (42; 242) produces, in use, a higher flow rate corresponding to a superficial velocity, in relation to the aerators (38; 238) receiving the flow of gas at the higher flow rate, of between 0.013 m/s and 0.15 m/s. 50
8. A device according to any preceding claim, wherein the lower flow rate is a gas-off condition. 55
9. A device according to any preceding claim, wherein the higher flow rate is provided for about one half of the duration of the cycle.
10. A device according to any preceding claim, wherein the flow of gas is alternated abruptly between the higher flow rate and the lower flow rate.
11. A device for treating water to produce a filtered permeate, comprising:
- a) a tank (12, 412, 512, 612) to hold the water;
  - b) one or more membrane modules (20, 220) mounted in the tank so as to be normally immersed in the water;
  - (c) means (28) to withdraw a filtered permeate from the one or more membrane modules; and
  - (d) means (237) to both (i) aerate the feed water with fouling-inhibiting bubbles and (ii) produce transient flow conditions in the water in the tank.
12. A device according to claim 11, wherein the one or more membrane modules (20) comprise hollow fibre membranes.
13. A method of operating a device according to any preceding claim.

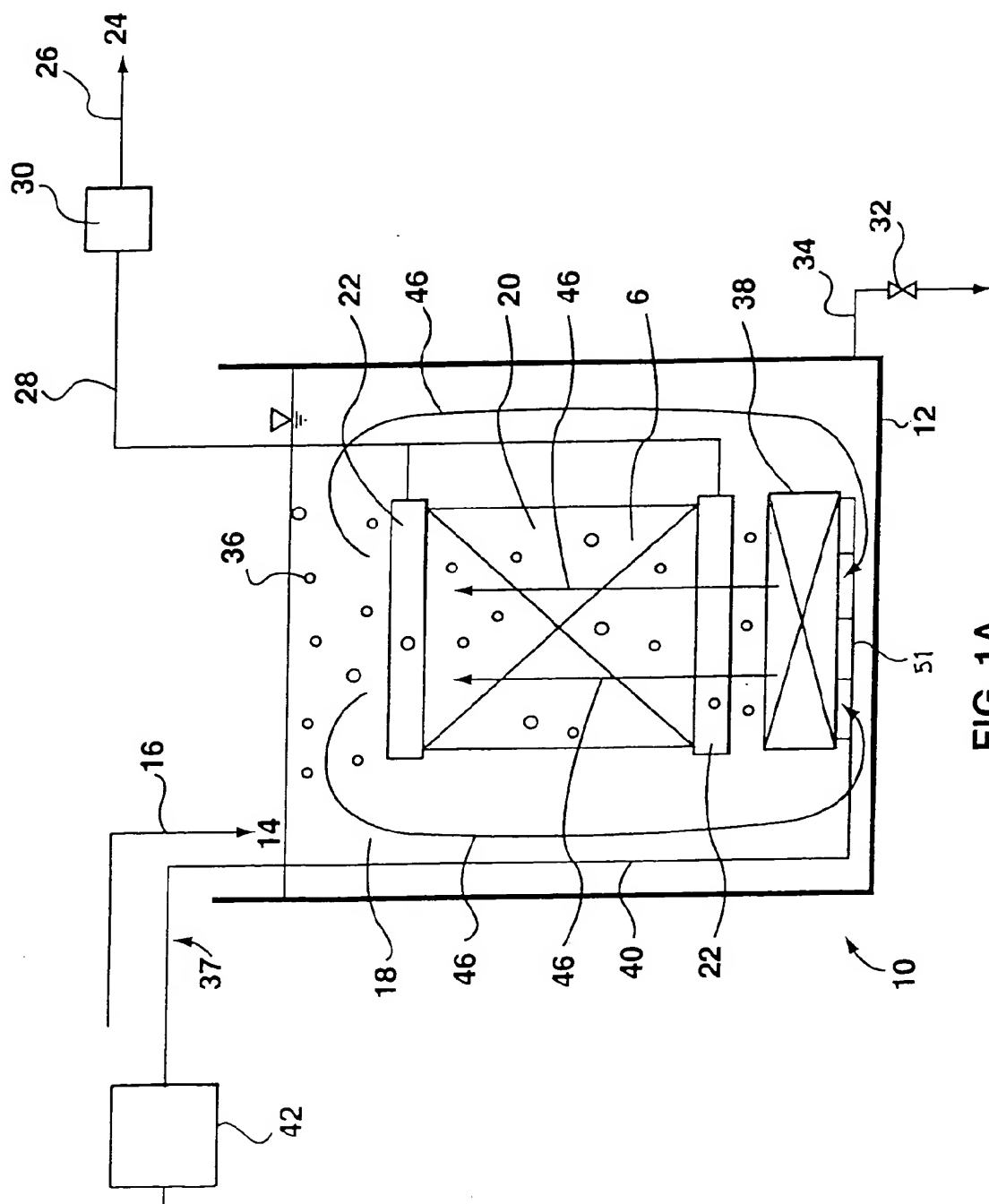
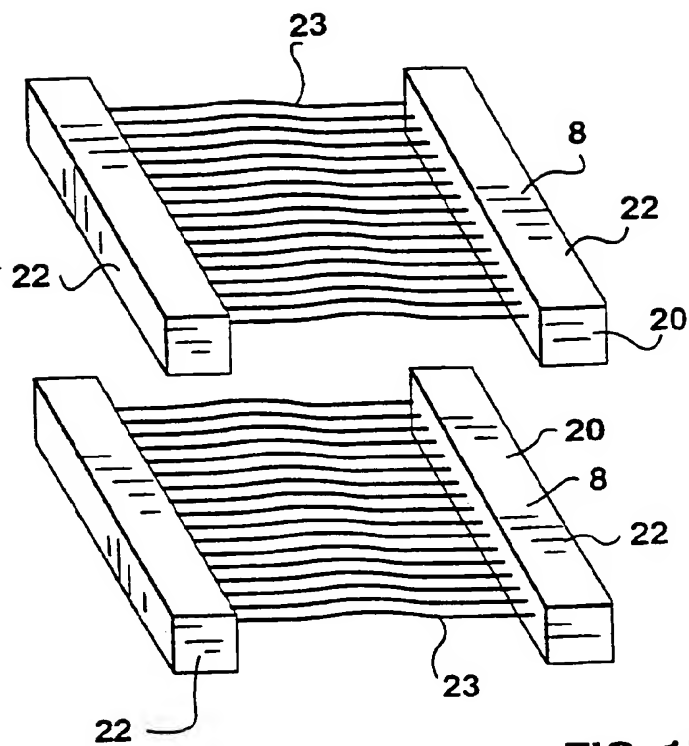
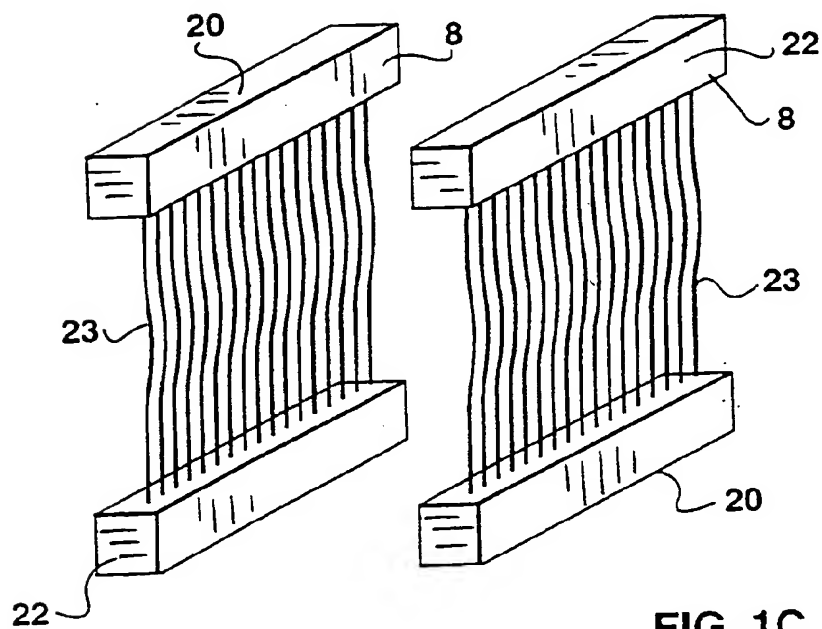


FIG. 1A



**FIG. 1B**



**FIG. 1C**

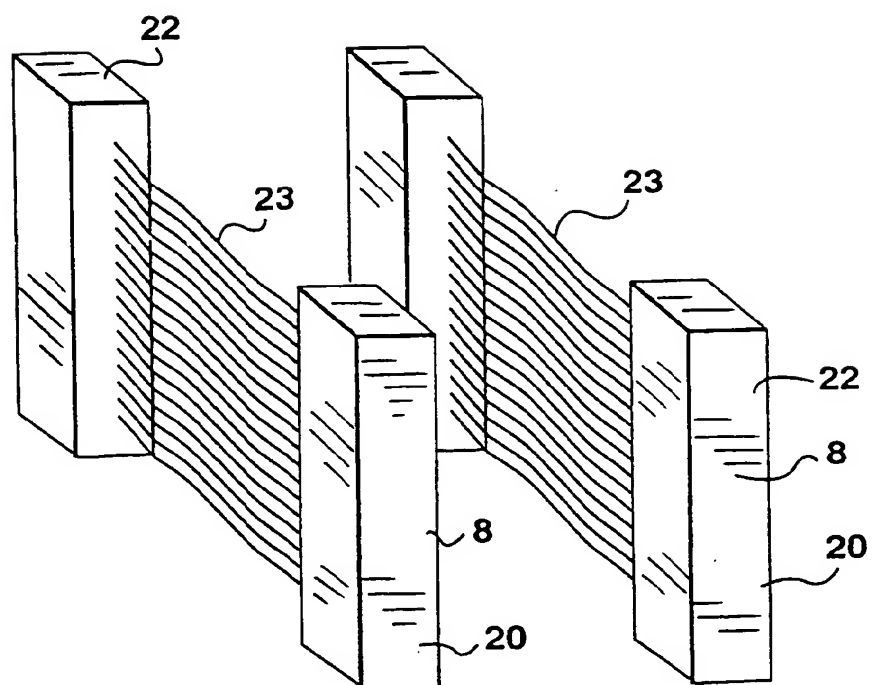


FIG. 1D

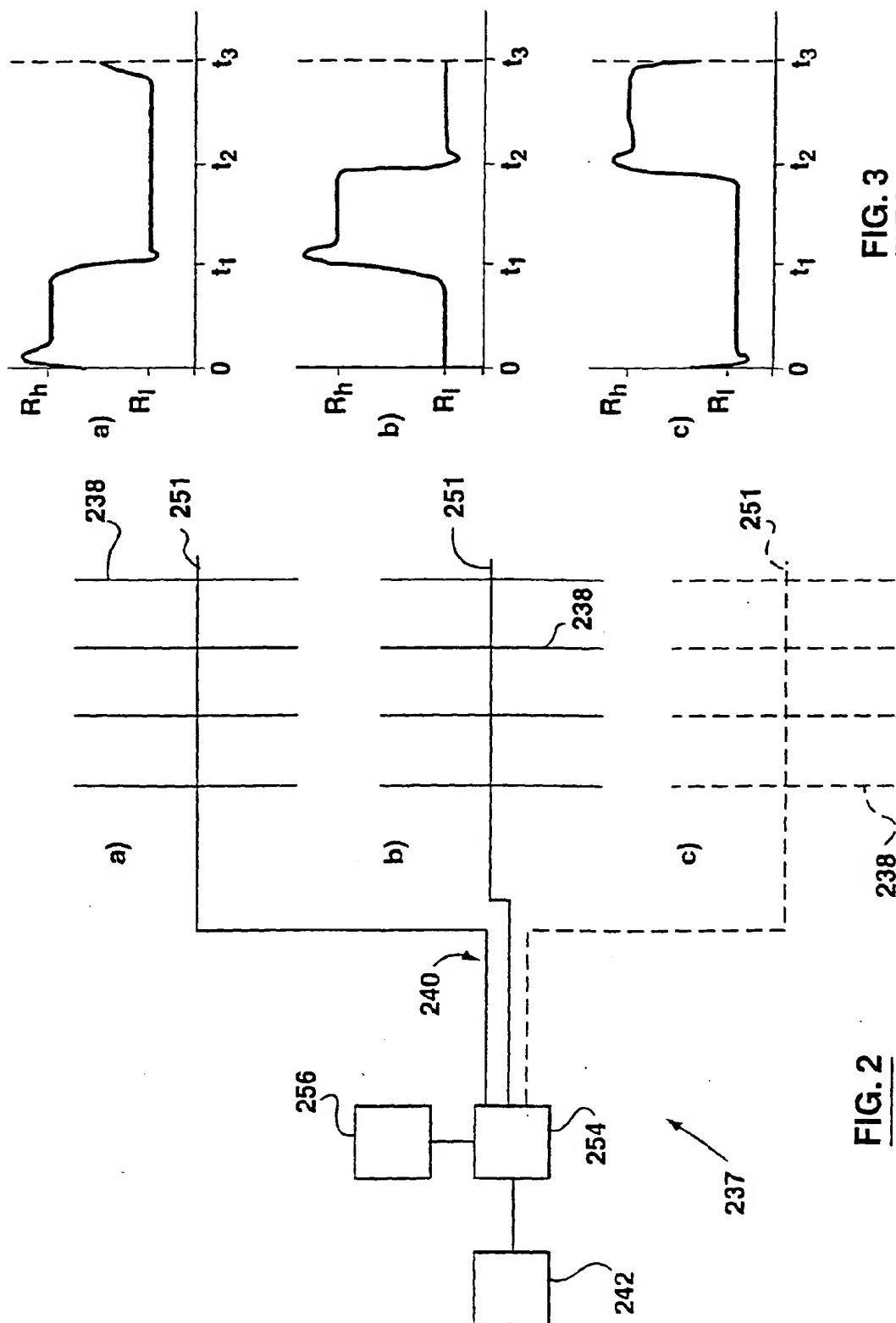
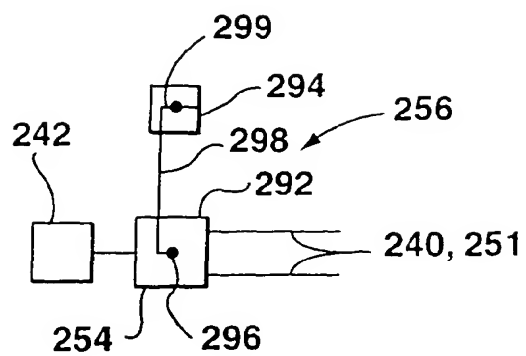
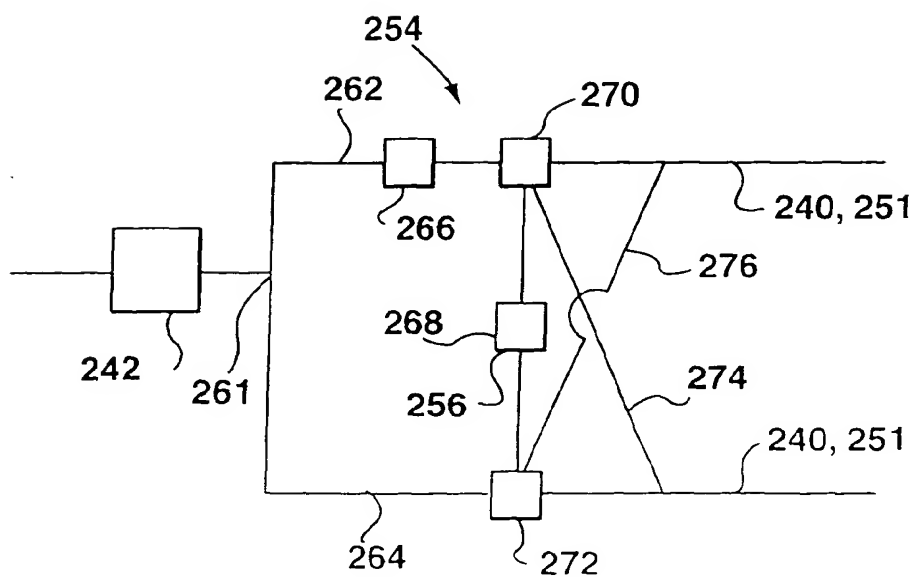


FIG. 3

FIG. 2



**FIG. 4A**



**FIG. 4B**



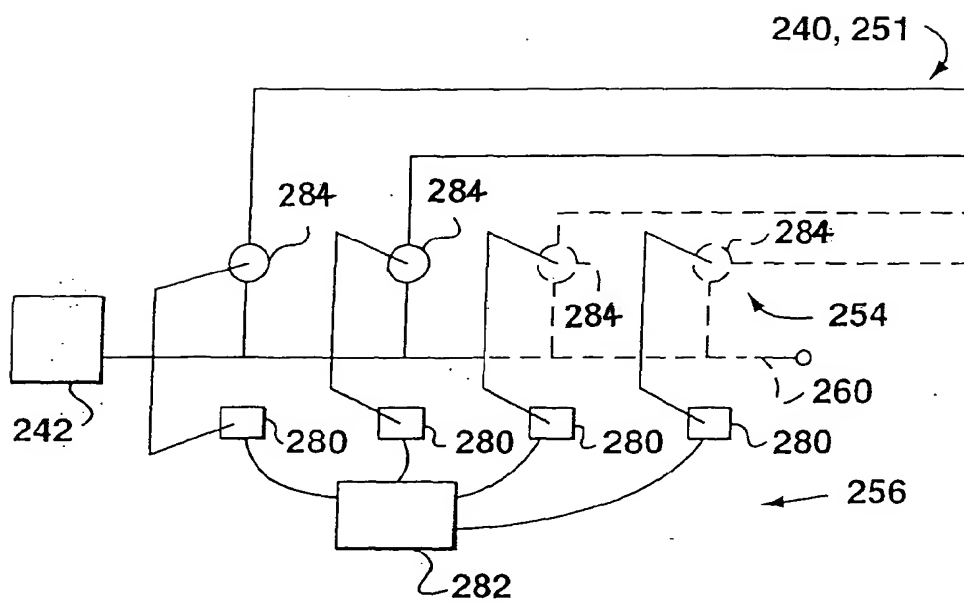


FIG. 4C

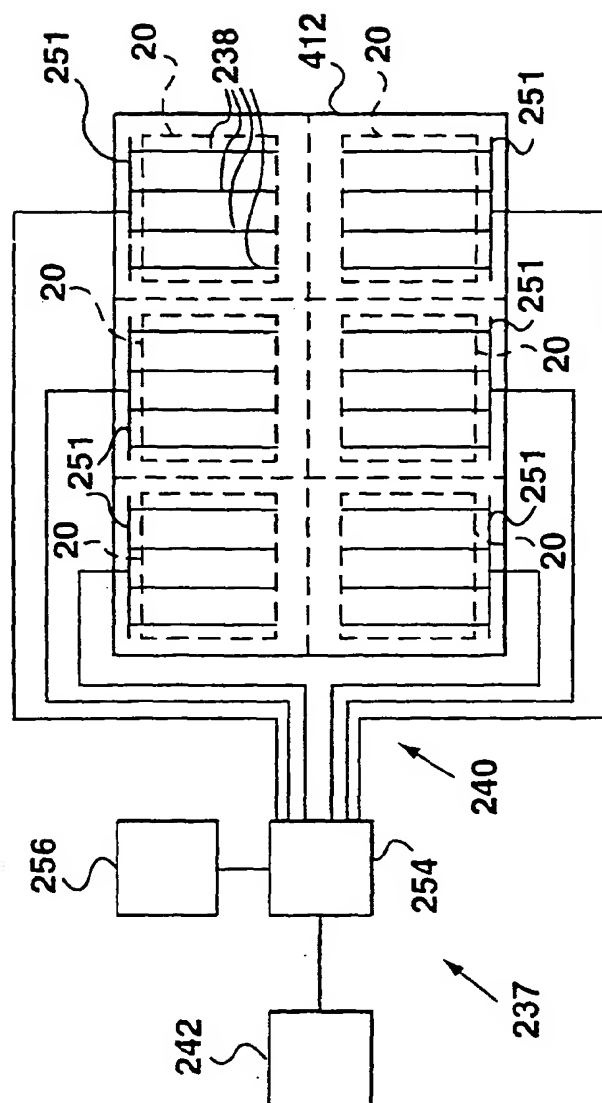
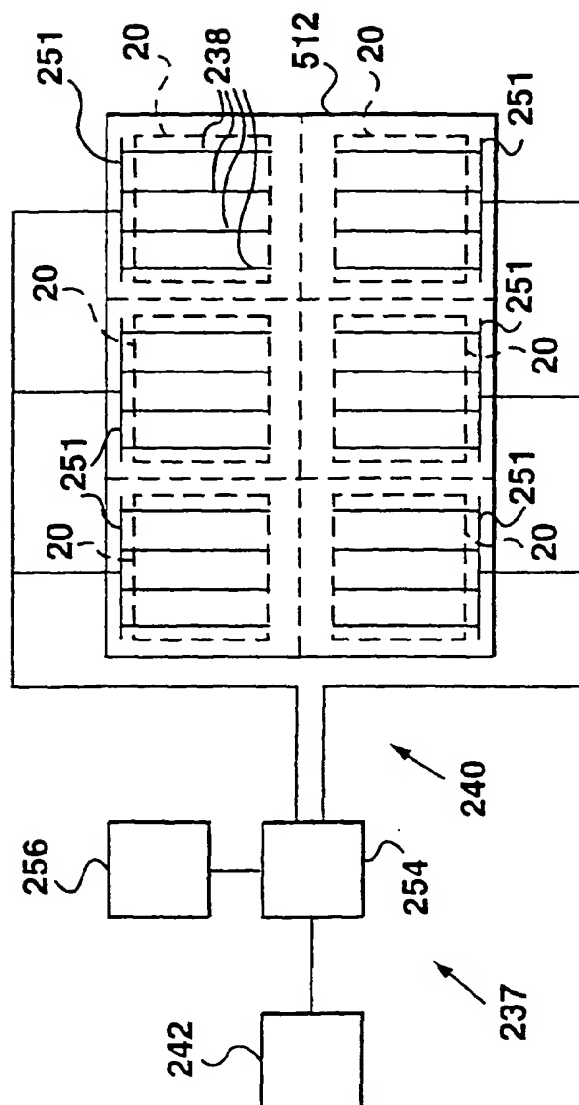


FIG. 5



**FIG. 6**

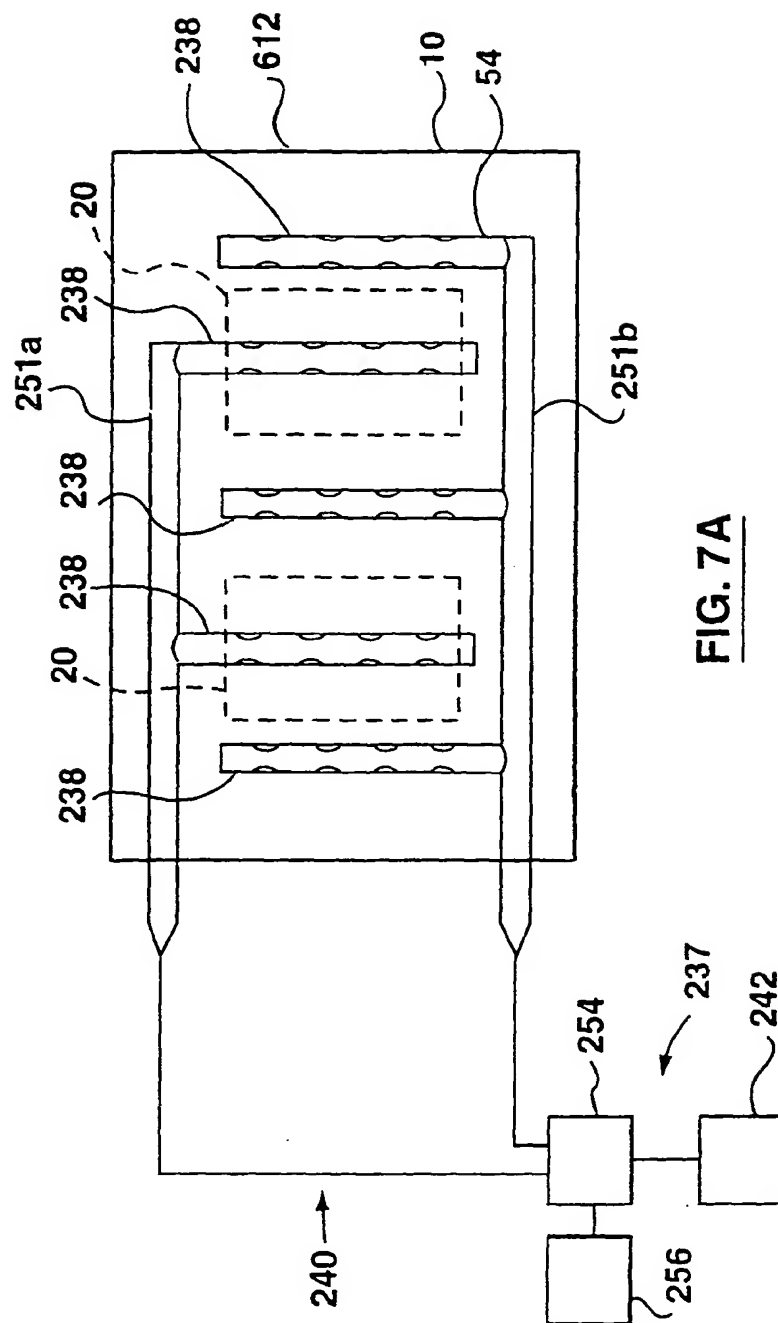
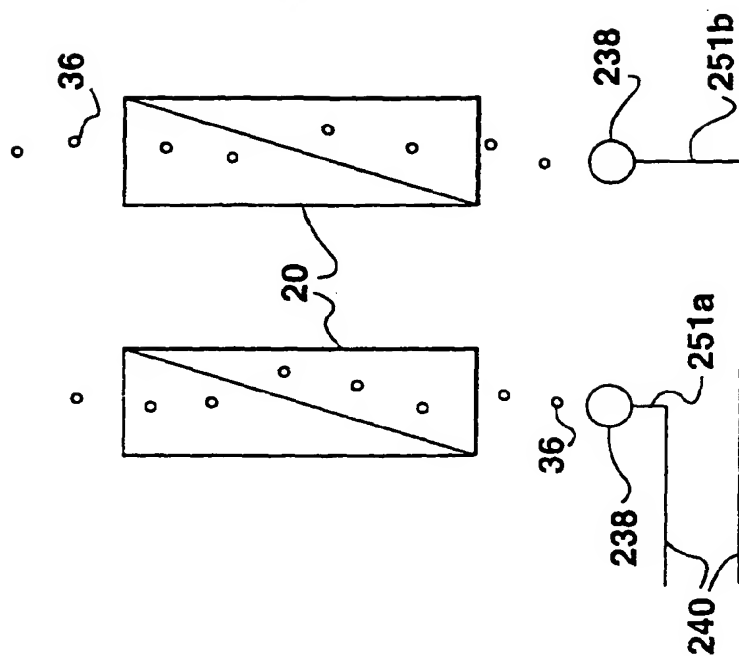
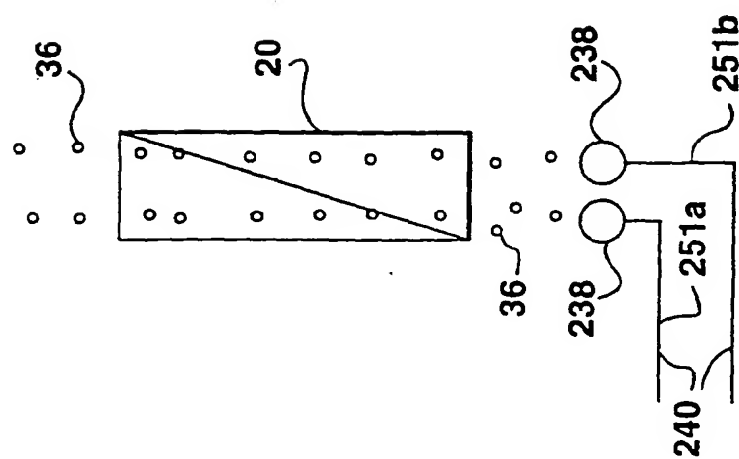


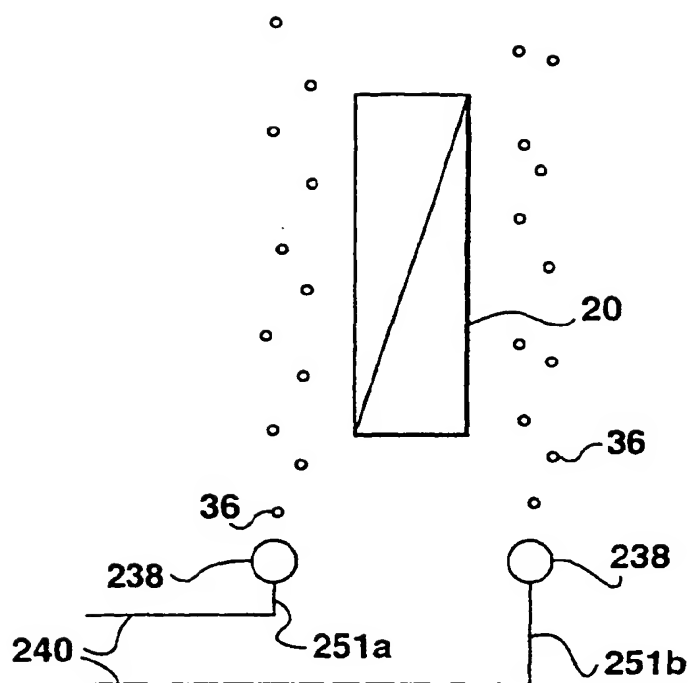
FIG. 7A



**FIG. 7C**



**FIG. 7B**



**FIG. 7D**

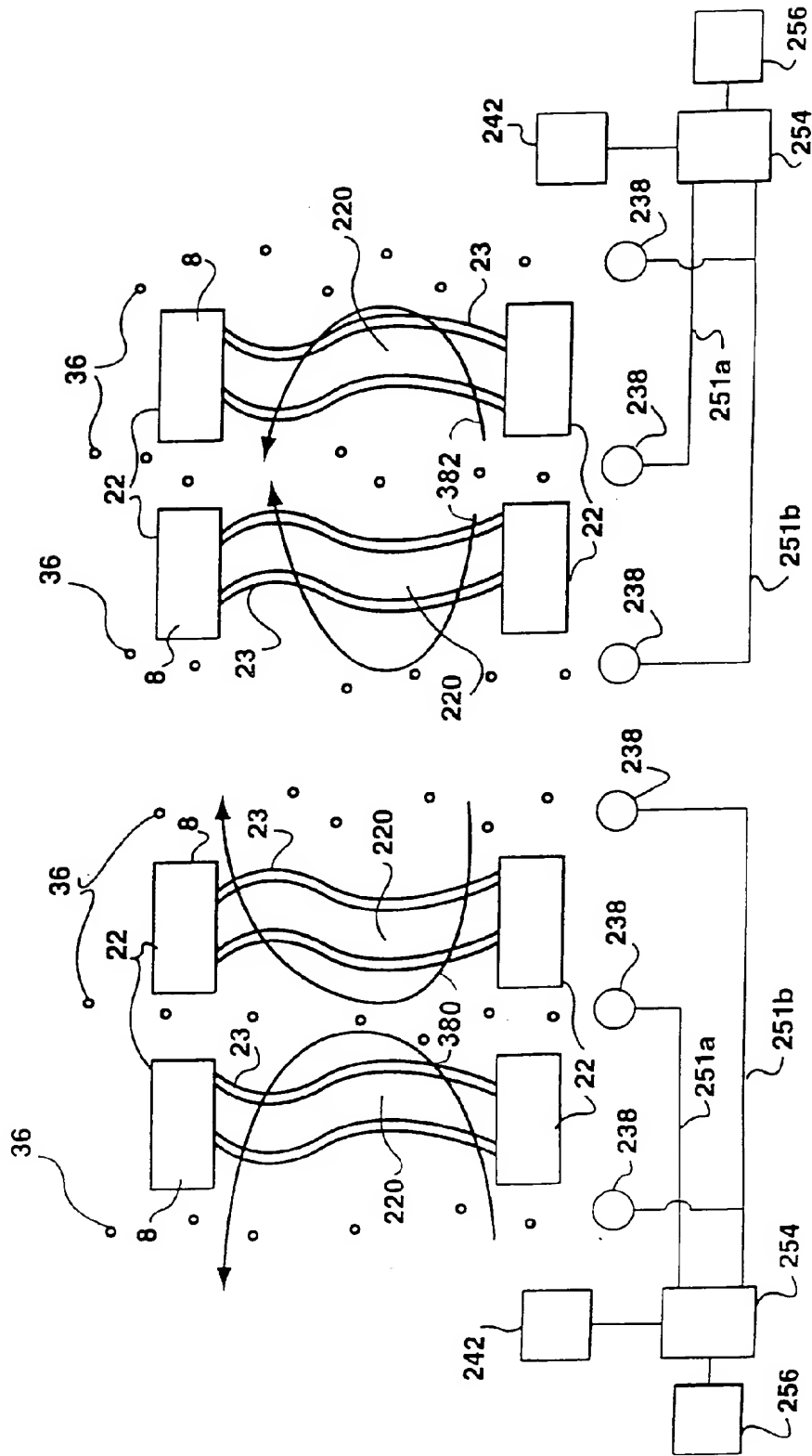


FIG. 8B

FIG. 8A

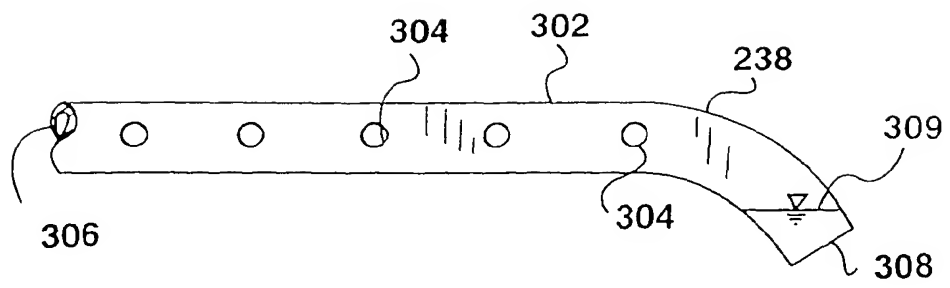
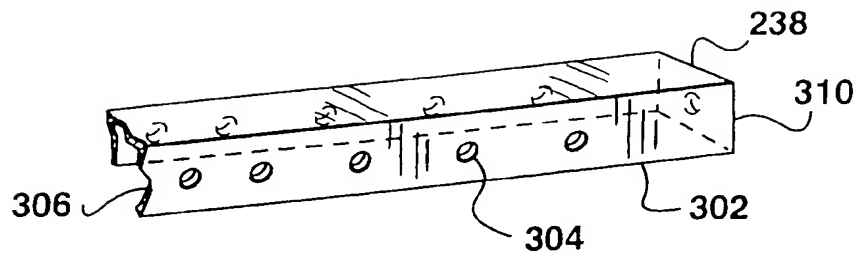
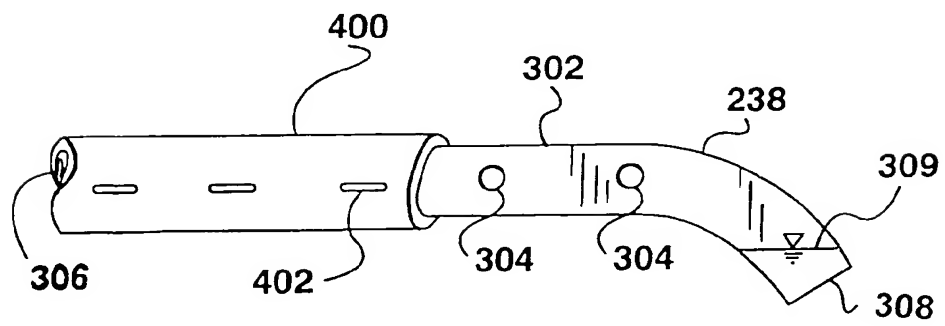


FIG. 9A





**FIG. 9B**



**FIG. 9C**

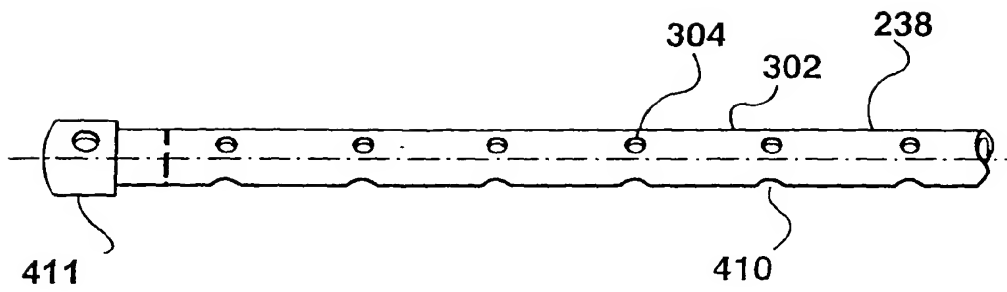
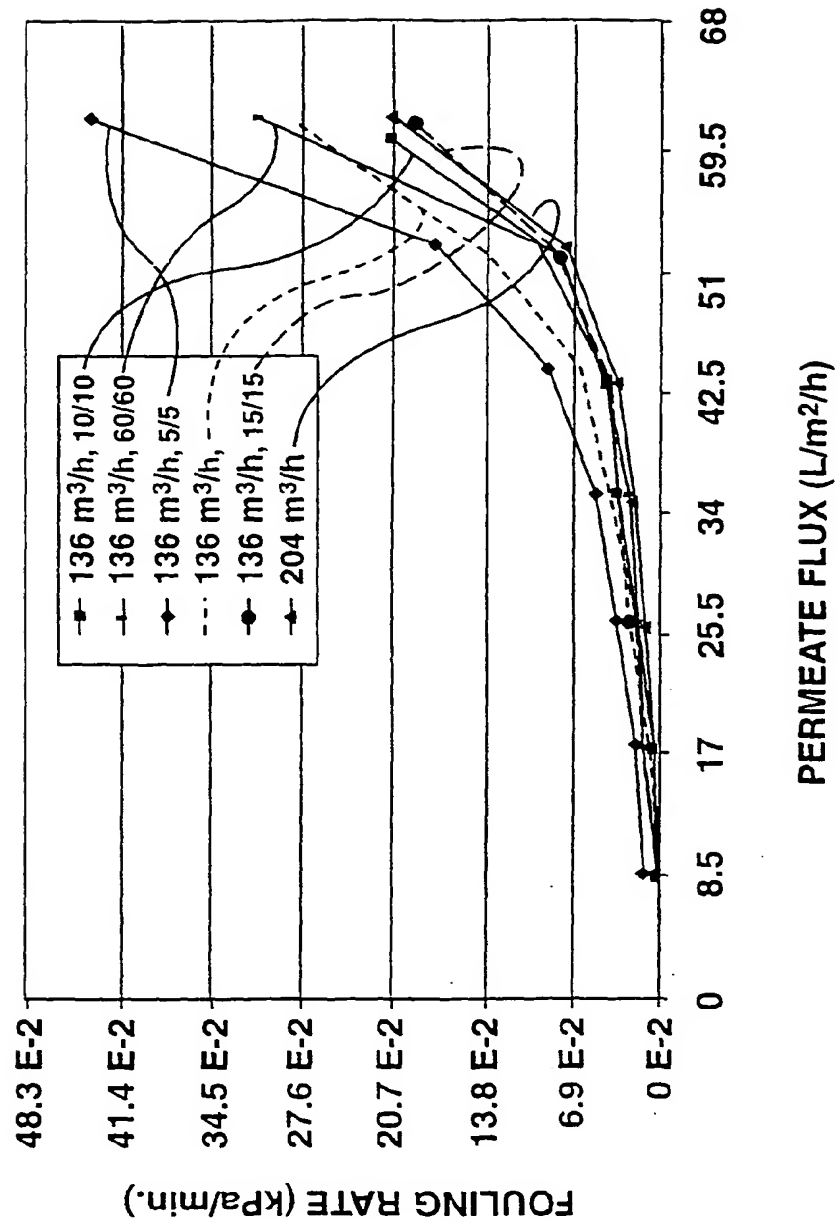
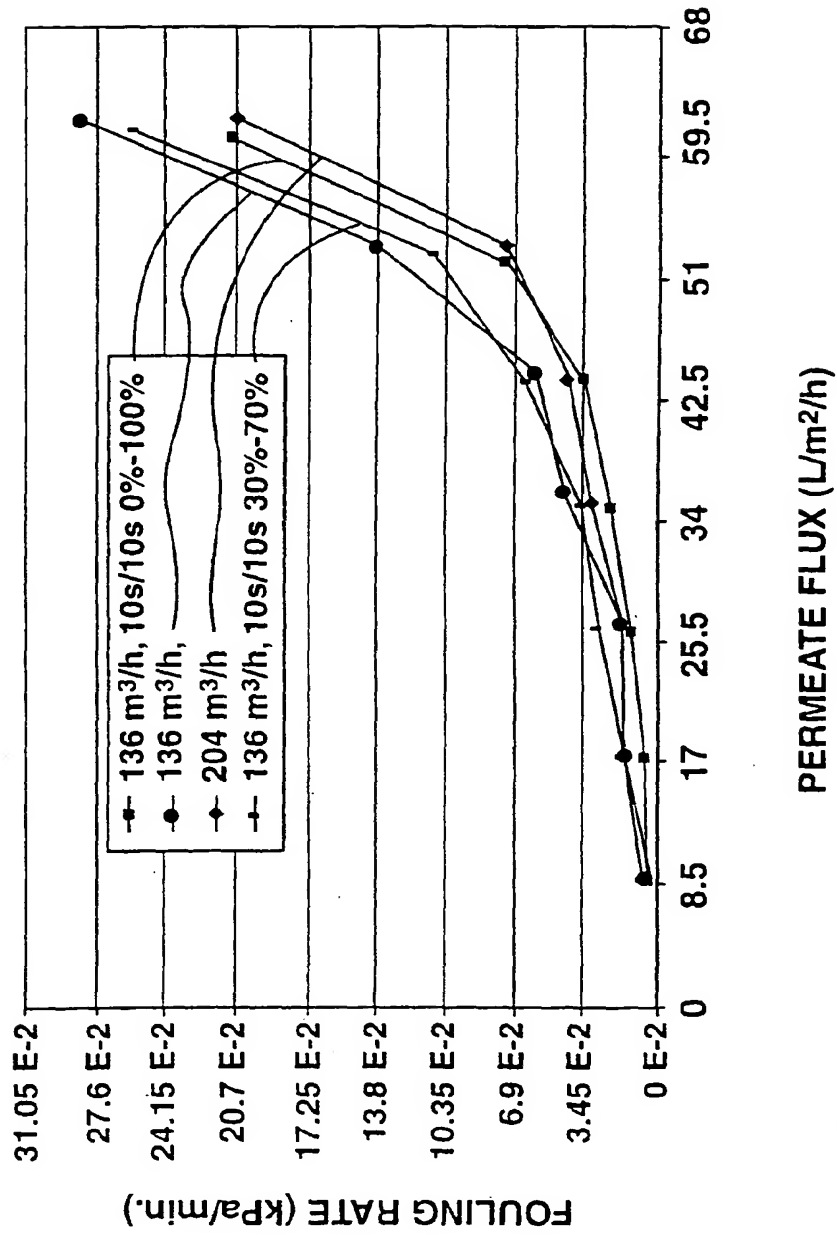


FIG. 9D



**FIG. 10A**

**FIG. 10B**

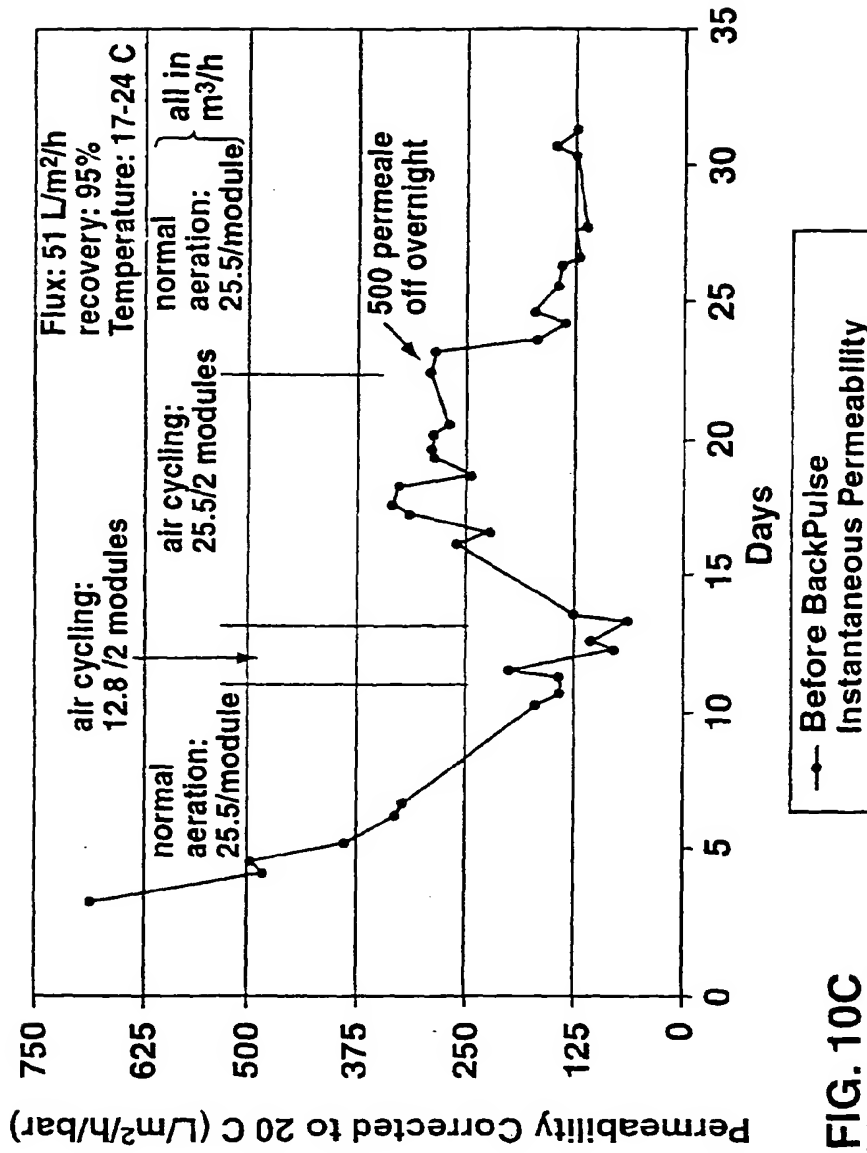
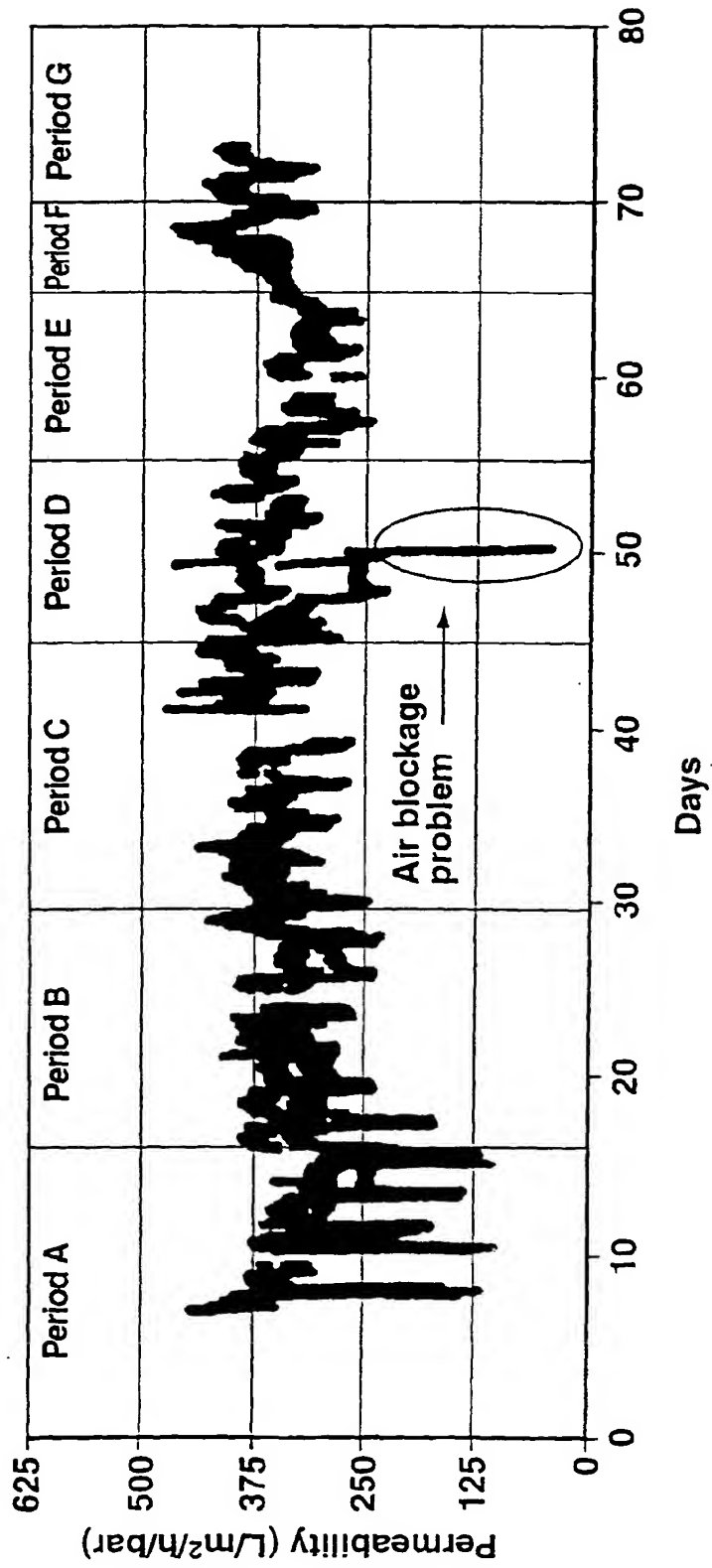


FIG. 10C



**FIG. 11**



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# EUROPEAN SEARCH REPORT

Application Number  
EP 04 00 4246

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IntCl.7)
X	PATENT ABSTRACTS OF JAPAN vol. 1995, no. 10, 30 November 1995 (1995-11-30) - & JP 07 185271 A (KURITA WATER IND LTD), 25 July 1995 (1995-07-25) * abstract * - & DATABASE WPI Section Ch, Week 199538 Derwent Publications Ltd., London, GB; Class J01, AN 1995-288178 XP002127730, 25 July 1995 (1995-07-25) * abstract *	1-13	C02F3/12 C02F1/44 C02F3/20 B01D65/02
X	--- PATENT ABSTRACTS OF JAPAN vol. 1997, no. 04, 30 April 1997 (1997-04-30) & JP 08 323161 A (HITACHI PLANT ENG & AMP; CONSTR CO LTD), 10 December 1996 (1996-12-10) * abstract * - & DATABASE WPI Section Ch, Week 199708 Derwent Publications Ltd., London, GB; Class D15, AN 1997-081592 XP002284169 & JP 08 323161 A (HITACHI PLANT ENG & CONSTR CO LTD), 10 December 1996 (1996-12-10) * abstract *	1-13	TECHNICAL FIELDS SEARCHED (IntCl.7)  C02F
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The present search report has been drawn up for all claims			
Place of search <b>BERLIN</b>		Date of completion of the search <b>14 June 2004</b>	Examiner <b>Gruber, M</b>
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	

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# EUROPEAN SEARCH REPORT

Application Number  
EP 04 00 4246

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int.Cl.7)
X	PATENT ABSTRACTS OF JAPAN vol. 013, no. 431 (C-640), 26 September 1989 (1989-09-26) -& JP 01 168304 A (KUBOTA LTD), 3 July 1989 (1989-07-03) * abstract; figures 3,4 *	1-13	
P,X	EP 0 937 494 A (KUBOTA KK) 25 August 1999 (1999-08-25) * column 1-2; figures 11,13,14 *	1-13	
A	US 5 639 373 A (MAHENDRAN MAILVAGANAM ET AL) 17 June 1997 (1997-06-17) * column 24, line 42 - column 25, line 16; figures 10,11 *	1-13	
A	PATENT ABSTRACTS OF JAPAN vol. 1997, no. 12, 25 December 1997 (1997-12-25) & JP 09 220569 A (KUBOTA CORP), 26 August 1997 (1997-08-26) * abstract *	1-13	
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Place of search BERLIN		Date of completion of the search 14 June 2004	Examiner Gruber, M
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